

Contents

Preface xiii

Chapter 1	Historical Introduction to Plastics	1
	<i>Introduction</i>	1
	<i>Natural Plastics</i>	1
	<i>Early Modified Natural Materials</i>	5
	<i>Early Synthetic Plastics</i>	8
	<i>Commercial Synthetic Plastics</i>	8
	<i>Summary</i>	8
	<i>Related Internet Sites</i>	10
	<i>Vocabulary</i>	10
	<i>Questions</i>	11
	<i>Activities</i>	11
Chapter 2	Current Status of the Plastics Industry	15
	<i>Introduction</i>	15
	<i>Major Plastics Materials</i>	16
	<i>Recycling of Plastics</i>	17
	<i>Disposal by Incineration or Degradation</i>	30
	<i>Organizations in the Plastics Industry</i>	32
	<i>Related Internet Sites</i>	34
	<i>Vocabulary</i>	34
	<i>Questions</i>	36
	<i>Activities</i>	36
Chapter 3	Elementary Polymer Chemistry	39
	<i>Introduction</i>	39
	<i>Review of Basic Chemistry</i>	39
	<i>Hydrocarbon Molecules</i>	40
	<i>Macromolecules</i>	41
	<i>Molecular Organization</i>	43
	<i>Intermolecular Forces</i>	46

<i>Molecular Orientation</i>	47
<i>Thermosets</i>	48
<i>Summary</i>	49
<i>Related Internet Sites</i>	49
<i>Vocabulary</i>	49
<i>Questions</i>	50
<i>Activities</i>	50

Chapter 4 Health and Safety 53

<i>Introduction</i>	53
<i>Physical Hazards</i>	53
<i>Biomechanical Hazards</i>	53
<i>Chemical Hazards</i>	53
<i>Sources of Chemical Hazards</i>	54
<i>Reading and Understanding MSDS</i>	54
<i>Related Internet Sites</i>	63
<i>Vocabulary</i>	63
<i>Questions</i>	64
<i>Activities</i>	64

Chapter 5 Elementary Statistics 65

<i>Introduction</i>	65
<i>Calculating the Mean</i>	65
<i>The Normal Distribution</i>	66
<i>Calculating the Standard Deviation</i>	67
<i>The Standard Normal Distribution</i>	68
<i>Graphical Representation of Hardness Test Results</i>	69
<i>Sketching Graphs</i>	70
<i>Graphic Comparison of Two Groups</i>	71
<i>Summary</i>	71
<i>Related Internet Sites</i>	72
<i>Vocabulary</i>	72
<i>Questions</i>	73
<i>Activities</i>	73

Chapter 6 Properties and Tests of Selected Plastics 75

<i>Introduction</i>	75
<i>Testing Agencies</i>	76
<i>Mechanical Properties</i>	76
<i>Physical Properties</i>	87
<i>Thermal Properties</i>	90
<i>Environmental Properties</i>	93
<i>Optical Properties</i>	98
<i>Electrical Properties</i>	99
<i>Related Internet Sites</i>	101
<i>Vocabulary</i>	101
<i>Questions</i>	102
<i>Activities</i>	102

Chapter 7	Ingredients of Plastics	105
	<i>Introduction</i>	105
	<i>Additives</i>	106
	<i>Reinforcements</i>	113
	<i>Fillers</i>	122
	<i>Related Internet Sites</i>	125
	<i>Vocabulary</i>	126
	<i>Questions</i>	127
	<i>Activities</i>	127
Chapter 8	Characterization and Selection of Commercial Plastics	129
	<i>Introduction</i>	129
	<i>Basic Materials</i>	129
	<i>Selection of Material Grade</i>	131
	<i>Computerized Databases for Material Selection</i>	132
	<i>Summary</i>	132
	<i>Related Internet Sites</i>	132
	<i>Vocabulary</i>	133
	<i>Questions</i>	134
	<i>Activities</i>	134
Chapter 9	Machining and Finishing	135
	<i>Introduction</i>	135
	<i>Sawing</i>	136
	<i>Filing</i>	137
	<i>Drilling</i>	138
	<i>Stamping, Blanking, and Die Cutting</i>	140
	<i>Tapping and Threading</i>	141
	<i>Turning, Milling, Planing, Shaping, and Routing</i>	143
	<i>Laser Cutting</i>	144
	<i>Induced Fracture Cutting</i>	145
	<i>Thermal Cutting</i>	145
	<i>Hydrodynamic Cutting</i>	145
	<i>Smoothing and Polishing</i>	145
	<i>Tumbling</i>	148
	<i>Annealing and Postcuring</i>	148
	<i>Related Internet Sites</i>	148
	<i>Vocabulary</i>	150
	<i>Questions</i>	151
	<i>Activities</i>	152
Chapter 10	Molding Processes	155
	<i>Introduction</i>	155
	<i>Injection Molding</i>	155
	<i>Molding Liquid Materials</i>	169
	<i>Molding Granular and Sheet Thermoset Materials</i>	171
	<i>Related Internet Sites</i>	177
	<i>Vocabulary</i>	177

Questions 178

Activities 178

Chapter 11 Extrusion Processes 183

Introduction 183

Extrusion Equipment 183

Compounding 186

Major Types of Extrusion Products 189

Blow Molding 199

Related Internet Sites 207

Vocabulary 208

Questions 209

Activities 209

Chapter 12 Laminating Processes and Materials 213

Introduction 213

Layers of Differing Plastics 214

Layers of Paper 215

Layers of Glass Cloth or Mat 218

Layers of Metal and Metal Honeycomb 219

Layers of Metal and Foamed Plastics 219

Related Internet Sites 222

Vocabulary 222

Questions 223

Activities 223

Chapter 13 Reinforcing Processes and Materials 227

Introduction 227

Matched Die 228

Hand Layup or Contact Processing 231

Spray-up 231

Rigidized Vacuum Forming 231

Cold-Mold Thermoforming 232

Vacuum Bag 232

Pressure Bag 233

Filament Winding 234

Centrifugal Reinforcing and Blown-Film Reinforcing 236

Pultrusion 236

Cold Stamping/Forming 237

Related Internet Sites 239

Vocabulary 239

Questions 239

Chapter 14 Casting Processes and Materials 241

Introduction 241

Material Types 241

Simple Casting 242

<i>Film Casting</i>	244
<i>Hot-Melt Casting</i>	244
<i>Slush Casting and Static Casting</i>	245
<i>Rotational Casting</i>	246
<i>Dip Casting</i>	248
<i>Related Internet Sites</i>	249
<i>Vocabulary</i>	249
<i>Questions</i>	250
<i>Activities</i>	250

Chapter 15 Thermoforming 255

<i>Introduction</i>	255
<i>Straight Vacuum Forming</i>	257
<i>Drape Forming</i>	258
<i>Matched-Mold Forming</i>	258
<i>Pressure-Bubble Plug-Assist Vacuum Forming</i>	258
<i>Plug-Assist Vacuum Forming</i>	260
<i>Plug-Assist Pressure Forming</i>	260
<i>Solid Phase Pressure Forming (SPPF)</i>	261
<i>Vacuum Snap-Back Forming</i>	262
<i>Pressure-Bubble Vacuum Snap-Back Forming</i>	263
<i>Trapped-Sheet Contact-Heat Pressure Forming</i>	263
<i>Air-Slip Forming</i>	264
<i>Free Forming</i>	264
<i>Twin Sheet Thermoforming</i>	265
<i>Blister Pack or Skin Pack Thermoforming</i>	265
<i>Mechanical Forming</i>	265
<i>Related Internet Sites</i>	266
<i>Vocabulary</i>	267
<i>Questions</i>	268
<i>Activities</i>	269

Chapter 16 Expansion Processes 273

<i>Introduction</i>	273
<i>Molding</i>	276
<i>Casting</i>	281
<i>Expanding in Place</i>	282
<i>Spraying</i>	282
<i>Related Internet Sites</i>	283
<i>Vocabulary</i>	283
<i>Questions</i>	284
<i>Activities</i>	285

Chapter 17 Coating Processes 291

<i>Introduction</i>	291
<i>Extrusion Coating</i>	291
<i>Calender Coating</i>	293

<i>Powder Coating</i>	294
<i>Transfer Coating</i>	295
<i>Knife or Roller Coating</i>	295
<i>Dip Coating</i>	296
<i>Spray Coating</i>	297
<i>Metal Coating</i>	297
<i>Brush Coating</i>	299
<i>Related Internet Sites</i>	301
<i>Vocabulary</i>	301
<i>Questions</i>	302
<i>Activities</i>	303

Chapter 18 Fabrication Processes and Materials 307

<i>Introduction</i>	307
<i>Mechanical Adhesion</i>	307
<i>Chemical Adhesion</i>	310
<i>Mechanical Fastening</i>	317
<i>Friction Fitting</i>	317
<i>Related Internet Sites</i>	318
<i>Vocabulary</i>	319
<i>Questions</i>	321
<i>Activities</i>	321

Chapter 19 Decoration Processes 327

<i>Introduction</i>	327
<i>Coloring</i>	328
<i>Painting</i>	328
<i>Hot-Leaf Stamping</i>	330
<i>Plating</i>	332
<i>Engraving</i>	332
<i>Printing</i>	332
<i>In-Mold Decorating</i>	333
<i>Heat-Transfer Decorating</i>	334
<i>Miscellaneous Decorating Methods</i>	334
<i>Related Internet Sites</i>	335
<i>Vocabulary</i>	335
<i>Questions</i>	336
<i>Activities</i>	337

Chapter 20 Radiation Processes 339

<i>Introduction</i>	339
<i>Radiation Methods</i>	339
<i>Radiation Sources</i>	341
<i>Irradiation of Polymers</i>	342
<i>Related Internet Sites</i>	347
<i>Vocabulary</i>	347
<i>Questions</i>	348

Chapter 21	Design Considerations	349
	<i>Introduction</i>	349
	<i>Material Considerations</i>	352
	<i>Design Considerations</i>	354
	<i>Production Considerations</i>	357
	<i>Related Internet Sites</i>	371
	<i>Vocabulary</i>	371
	<i>Questions</i>	372
Chapter 22	Tooling and Moldmaking	373
	<i>Introduction</i>	373
	<i>Planning</i>	374
	<i>Tooling</i>	374
	<i>Machine Processing</i>	378
	<i>Related Internet Sites</i>	384
	<i>Vocabulary</i>	385
	<i>Questions</i>	386
Chapter 23	Commercial Considerations	387
	<i>Introduction</i>	387
	<i>Financing</i>	387
	<i>Management and Personnel</i>	388
	<i>Plastics Molding</i>	388
	<i>Auxiliary Equipment</i>	389
	<i>Molding Temperature Control</i>	392
	<i>Pneumatics and Hydraulics</i>	392
	<i>Price Quotations</i>	393
	<i>Plant Site</i>	394
	<i>Shipping</i>	394
	<i>Related Internet Sites</i>	394
	<i>Vocabulary</i>	395
	<i>Questions</i>	396
Appendix A	Glossary	397
Appendix B	Abbreviations for Selected Materials	409
Appendix C	Trade Names and Manufacturers	411
Appendix D	Material Identification	425
	<i>Identifying Plastics</i>	425
	<i>Identification Methods</i>	425
Appendix E	Thermoplastics	431
	<i>Polyacetal Plastics (POM)</i>	431
	<i>Acrylics</i>	432

<i>Cellulosics</i>	437
<i>Chlorinated Polyethers</i>	441
<i>Coumarone-Indene Plastics</i>	442
<i>Fluoroplastics</i>	442
<i>Ionomers</i>	448
<i>Nitrile Barrier Plastics</i>	450
<i>Phenoxy</i>	450
<i>Polyallomers</i>	451
<i>Polyamides (PA)</i>	452
<i>Polycarbonates (PC)</i>	454
<i>Polyetheretherketone (PEEK)</i>	457
<i>Polyetherimide (PEI)</i>	457
<i>Thermoplastic Polyesters</i>	457
<i>Thermoplastic Polyimides</i>	459
<i>Polymethylpentene</i>	460
<i>Polyolefins: Polyethylene (PE)</i>	462
<i>Polyolefins: Polypropylene</i>	468
<i>Polyolefins: Polybutylene (PB)</i>	471
<i>Polyphenylene Oxides</i>	471
<i>Polystyrene (PS)</i>	474
<i>Polysulfones</i>	477
<i>Polyvinyls</i>	479

Appendix F Thermosetting Plastics 485

<i>Alkyds</i>	485
<i>Allylics</i>	487
<i>Amino Plastics</i>	489
<i>Casein</i>	493
<i>Epoxy (EP)</i>	494
<i>Furan</i>	497
<i>Phenolics (PF)</i>	498
<i>Unsaturated Polyesters</i>	500
<i>Thermosetting Polyimide</i>	504
<i>Polyurethane (PU)</i>	505
<i>Silicones (SI)</i>	507

Appendix G Useful Tables 513

Appendix H Sources of Help and Bibliography 519

<i>Sources of Help</i>	519
<i>Bibliography</i>	520

Index 523